

## **ABSTRACT**

Please add the following abstract:

The invention relates to a method for forge welding tubulars such that formation of upsets in the welding zone is minimized which involves shaping the tubular ends that are to be welded together into an inwardly sloping configuration such that when the tubular ends are heated during the forge welding process the heated tubular ends deform as a result of thermal expansion into a substantially longitudinally oriented cylindrical shape.